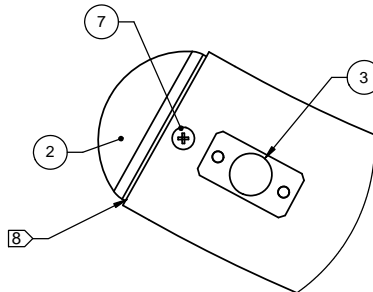
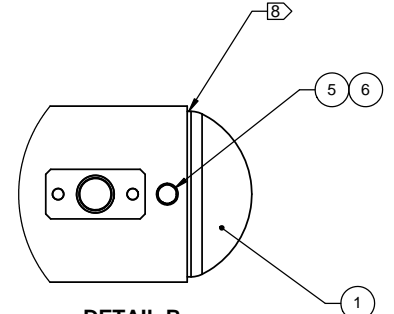


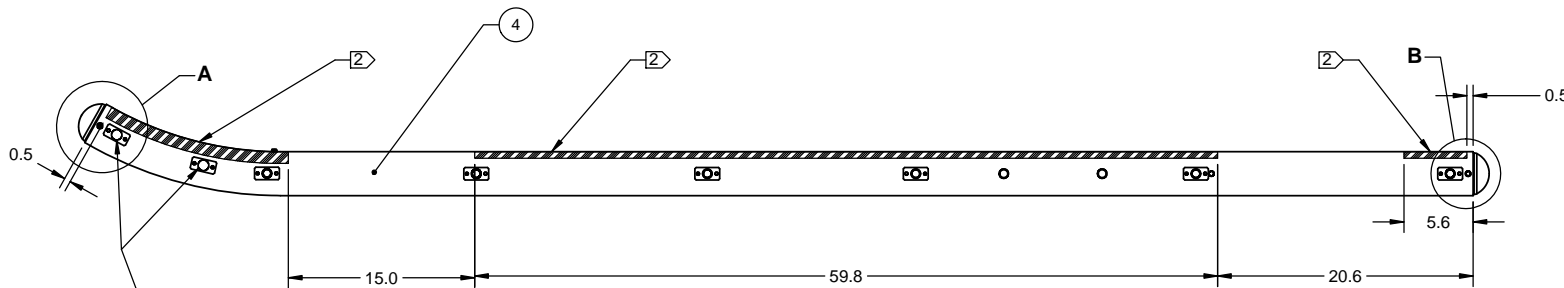
ITEM	QTY -041	P/N	DESCRIPTION
	X	D4680-041	SKIDTUBE
1	1	D2965	CAP
2	1	D2965-3	CAP
3	4	D3492-055	PLUG ASSY
4	1	D4680-043	SKIDTUBE SUB ASSY
5	2	AN3C5A	BOLT
6	2	AN960-10L	WASHER
7	2	AN526C1032-10	SCREW



**DETAIL A**  
SCALE 4X



**DETAIL B**  
SCALE 4X

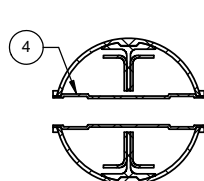


**D4680-041 SKIDTUBE**

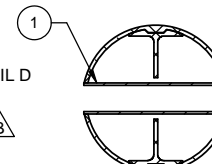
- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 1.00 ABOVE CENTERLINE PER QSI 005 4.4.
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4680-041" AND B/N PER QSI 044 METHOD 6.4 ON INNER RADIUS OF SKIDTUBE BEFORE INSTALLING D2965 CAP
  - 7) WEIGHT: 18.52 lbs
  - 8) SEAL FAYING SURFACES WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

B	FWD CAP WAS D2965, NOW D2965-3. VARIOUS DIMENSIONAL CHANGES. D3492-055 PLUG ASSY WAS D3492-051. SWAGING DIMENSION NOW 0.650 WAS 0.661 (D6-2). ADDED DETAIL H (C2-3). MATERIAL D2962-150 WAS D2962-131 (A7-3). GROUND HANDLING THRU HOLES NOW WELDED.	AP	13.09.10
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	AP		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4680</b>	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>SKIDTUBE</b>	NTS
DATE	13.09.10	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4680-043	SKIDTUBE SUB ASSY
1	2	D2973	SPACER
2	1	D4680-1	SKIDTUBE
3	1	D4681-041	WEB
4	8	D4686-1	SPACER
5	16	D4753-1	DOUBLER
6	3	AELS-1032-130	INSERT
7	3	AN3C4A	BOLT
8	3	AN960-10L	WASHER
9	32	MS20601AD4W3	RIVET



**SECTION C-C** 10  
SCALE 4X  
8 PL



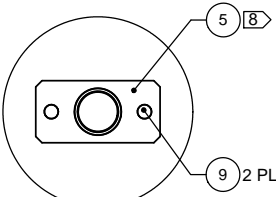
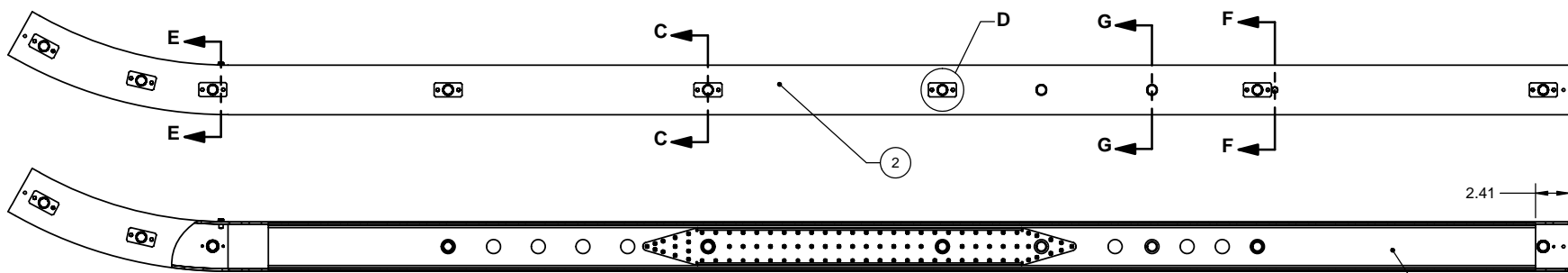
**SECTION G-G** 11  
SCALE 4X  
2 PL

INSTALL D4686-1 SPACER AS FOLLOWS (8 PL)  
AFTER INSTALLING D4753-1 DOUBLERS PER DETAIL D

1. INSERT D4686-1 SPACER
2. SWAGE TO  $\varnothing 0.650 +0.010/-0.000 \times 1.0$   
DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

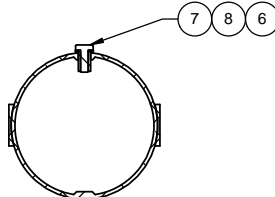
INSTALL D2973 SPACER AS FOLLOWS (2 PL)

1. CHAMFER HOLE 0.030X45 DEG
2. INSERT D2973 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS  $\varnothing 0.625$  DRILL TO REMOVE SPILL OVER

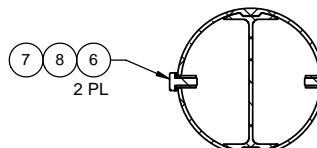


**DETAIL D**  
16 PL (BOTH SIDES)  
SCALE 4X

**D4680-043 SKIDTUBE SUB ASSY**



**SECTION E-E**  
SCALE 2.5X

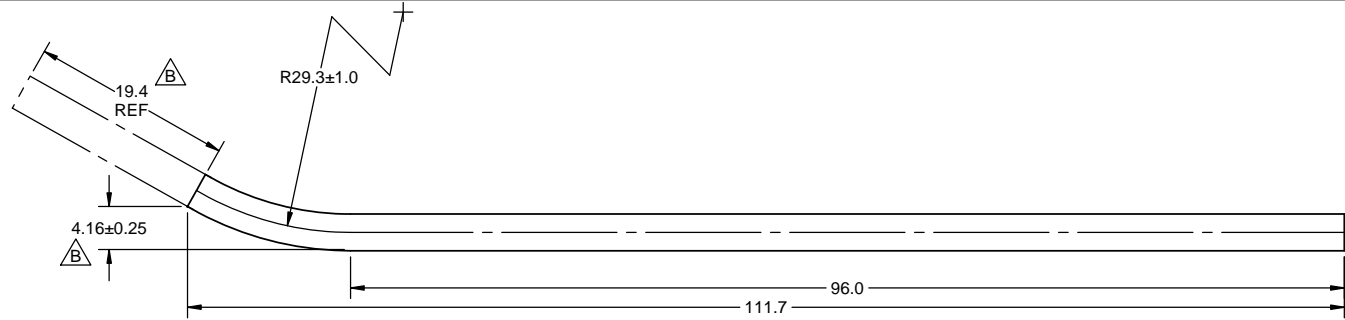


**SECTION F-F**  
SCALE 2.5X

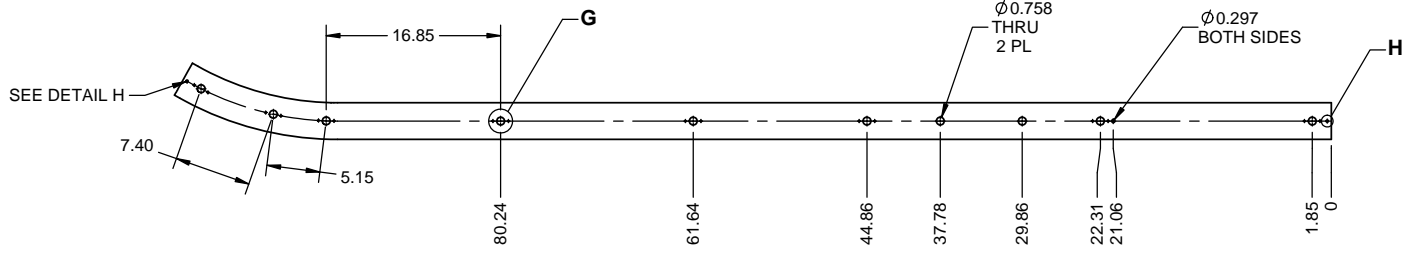
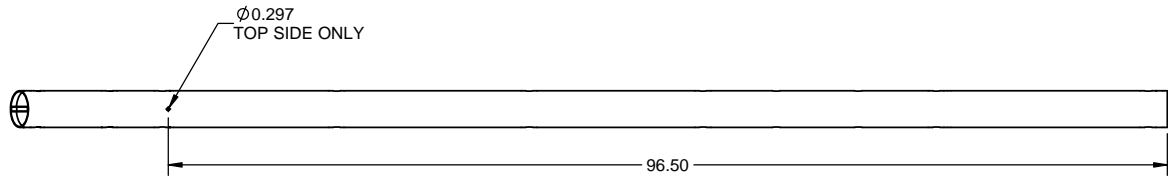
- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: APPLY SHERWIN WILLIAMS PRIMER (CM0483928) PER DART QSI 005 4.2.  
PAINT TWO COATS OF SHERWIN WILLIAMS (CM0143603GA) GLOSS WHITE PER DART QSI 005 4.2.  
APPLY TWO COATS OF SHERWIN WILLIAMS CLEAR COAT (CM0571080) PER DART QSI 005 4.2.
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 17.87 lbs
  - 8) SEAL ALL FAYING SURFACES USING PROSEAL 890 B-2 (PRC).
  - 9) INSERT D4681-041 WEB INTO D4680-1 SKIDTUBE IN LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX -241/-291 ADHESIVE PER DART QSI 015.
  - 10) INSTALL D4686-1 SPACER AFTER INSTALLING D4753-1 DOUBLERS.
  - 11) WELDING: PER QSI 004

**PRELIMINARY PB4  
A.P. 13.09.24**

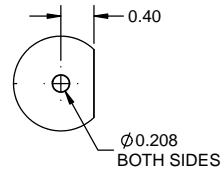
DESIGN	AP	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	AP		
CHECKED		DRAWING NO.	REV. PB4
MFG. APPR.		D4680	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE	NTS
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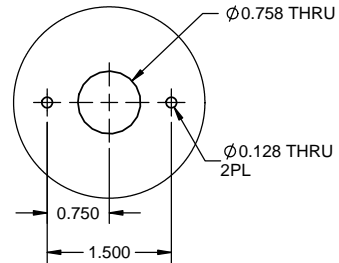
**D4680-1 SKIDTUBE BENDING/TRIMMING DETAIL**



**D4680-1 SKIDTUBE DRILLING DETAIL**



**DETAIL H**  
SCALE 8X  
2 PL



**DETAIL G**  
SCALE 8X  
8 PL

- NOTES:**
- 1) MATERIAL: MAKE FROM D2962-150 EXTRUSION B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 11.36 lbs

DESIGN	AP	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	AP		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4680</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>SKIDTUBE</b>	NTS
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